

SPLIT

Dart Aerospace Ltd.

Date: Tuesday, 28/08/2007 9:28:27 AM  
User: Linda Lacelle

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : WEARPAD

Job Number : 34282

Estimate Number : 12712

P.O. Number : N/A

This Issue : 28/08/2007

S.O. No. : N/A

Prsht Rev. : NC

First Issue : N/A

Type : SMALL / MED FAB

Previous Run : 33967

Part Number : D35371

Drawing Number : D3537 REV C

Project Number : N/A

Drawing Revision : C

Material : N/A

Due Date : 09/09/2007

Qty: 100 Um: Each

Written By :

Checked & Approved By :

Comment : Est Rev:A New Issue 07-02-14 JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M304S16GA

304/316 .063 Sheet



Comment: Qty.: 0.0788 sf(s)/Unit Total: 7.8750 sf(s)

M304S16GA .063" 304 SS SHEET

Batch: M105130

WB 07-08-28

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1 Cut as per Dwg D3537

Dwg Rev: C

Prog Rev: C

WB 07-08-28

2-Deburr if necessary

SAD 07/09/19

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

WB 07-08-28

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

07/09/19

counters

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326.

2-Identify as D3537-1

SB 07/09/19





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Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch

A/R 2059B Hardcoat

1-Weld as per Dwg D3537 using Jig DT 8210

2-Remove any weld that penetrated through Wearpad if necessary

*M105465 / M105599 FC 07/10/15*

*92*

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*PD 07-10-16 90*

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*PD 07-10-16 91*

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

*M104846*

*m-k 07/10/17*

*91X*

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*07-10-17 91*

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *FP-17*

*PD 07-10-17*

*91*

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*91*  
*07/10/18*

Job Completion



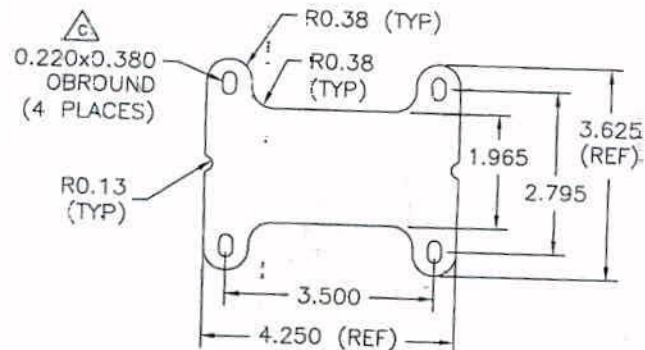
*U 07-10-18*

Handwritten notes in the left margin, including the word "Lithology" and some illegible text.

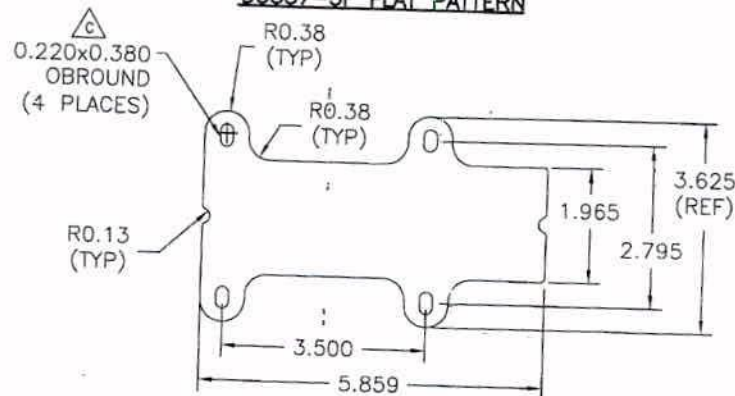
Section 1000, 1000, 1000

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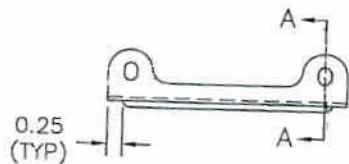
### D3537-1F FLAT PATTERN



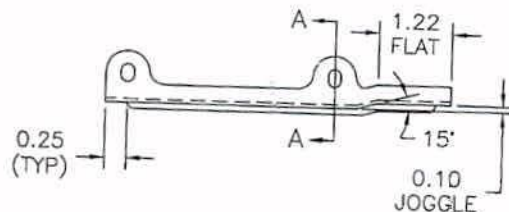
### D3537-3F FLAT PATTERN



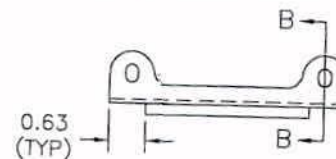
### D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



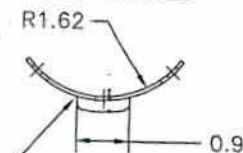
### D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



### D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)

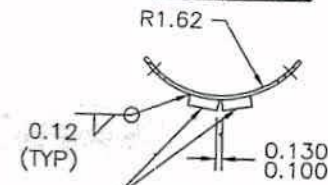


### SECTION A-A



APPLY 2 LAYERS OF  
2059B HARDCOAT WELDS  
TO WITHIN 0.25 OF  
WEARPAD ENDS  
0.188 TO 0.250 THICK

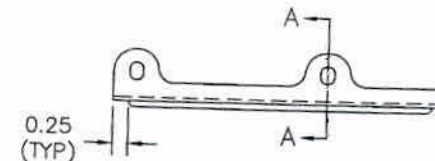
### SECTION B-B



D2941-300  
REMOVE POWDER  
COAT FROM THESE  
SURFACES

**RELEASED**  
07.05.08 AM  
REV ECU  
952

### D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



### D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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|         |          |                                  |
|---------|----------|----------------------------------|
| C       | 07.04.13 | WIDEN TAB TO 0.380, WELD PATTERN |
| B       | 07.03.20 | ADD AMS 5513 AND AMS 5524        |
| A       | 06.11.06 | NEW ISSUE                        |
| DESIGN  | CB       | DRAWN BY PH                      |
| CHECKED | 4        | APPROVED 4                       |
| DATE    | 07.04.13 | DRAWING NO. D3537                |
|         |          | TITLE WEARPAD                    |
|         |          | REV. C                           |
|         |          | SHEET 1 OF 1                     |
|         |          | SCALE 1:2                        |

**DART** DART AEROSPACE USA, INC.  
PORT HADLOCK, MA

